



TECHNICAL DATA SHEET



THICK CA HOBBY GLUE PART NO. 13416

DESCRIPTION:

DynaGrip Thick CA HOBBY GLUE is a high viscosity, cyanoacrylate adhesive with slower cure speed compare to other cyanoacrylate adhesives. This adhesive develops strong bonds on wide variety of metals, plastics, and elastomeric compounds.

APPLICATIONS:

- Specially formulated to bond various plastics, metals and elastomers.
- Rough or irregular surfaces.
- Applications requiring alignment time of up to 15 seconds.
- Meets MIL-A-46050C type II class III.

BONDS:

Acrylic	Polycarbonate	Polyimide
PVC	PEEK	PETG
Polysulfone	PET	Latex
ABS	Rubber	Metals

BONDING TIMES:

Under normal conditions, the surface moisture initiates the curing process. Functional strength developed in a short-time but curing continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on substrate used.

Steel	25-35 seconds	ABS	10-30 seconds
Polycarbonate	15-50 seconds	PVC	10-30 seconds
Neoprene	< 5 seconds	Phenolics	10-15 seconds
Aluminium	10-20 seconds	Nitrile Rubber	5 – 7 seconds

PHYSICAL PROPERTIES:

Liquid

Composition	Ethyl Cyanoacrylate Adhesive
Appearance	Colourless liquid
Viscosity	1500 cps @ 25°C Brookfield LVF

Cured Adhesive

Gap Filling	0.45 mm
Tensile Shear Strength	15-22 n/mm ²
Service Temperature Range	-60 to +80 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C



Mechanical Properties

Glass Transition Temperature, ASTM E228, °C	125
Dielectric Strength, ASTM D149, v/mil	625
Coefficient of thermal expansion, ASTM D696, K ⁻¹	90 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1

Shear Strength ASTM D 1002/DIN 53283

Neoprene Rubber	10-15 N/mm ²
PVC	6-9 N/mm ²
Acrylic	10-15 N/mm ²
Polycarbonate	5-10 N/mm ²
ABS	8-14 N/mm ²

APPLICATION INSTRUCTIONS

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.
- Thin bond lines favour high cure speed. Increasing the bond gap will slow down the rate of cure.

DIRECTIONS:

1. Ensure parts are clean and dry.
2. Protect clothing and work surfaces. Use in a well-ventilated area. Carefully open bottle while keeping bottle pointed away from face.
3. Apply glue to one surface. Assemble parts and hold together with pressure for 30-40 seconds or until set.
4. After use wipe top of nozzle to remove any excess glue before recapping bottle securely.
5. Store upright in a cool area away from sunlight or heat sources. Once open, product has a 12month shelf life.

NOTE: Not for use with Teflon, polyethylene, polypropylene, certain silicone rubber types, glass, rear view mirrors or parts that are subjected to great shock or continuous immersion in water.

CAUTION: EYE IRRITANT. BONDS SKIN & EYES IN SECONDS. Contains ethyl cyanoacrylate. Use with adequate ventilation. Avoid contact with clothing as can cause burn. In case of eye contact, flush with water for 15 minutes; get medical attention for eye or internal contact. To remove from skin, soak in acetone nail polish remover & gently peel adhesive off with fingernail; water exposure will wear off residual adhesive in a few days (do not use polish remover around eye area). **KEEP OUT OF REACH OF CHILDREN.**

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